

HAWKEYE

INTERNATIONAL, LTD.

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DATA SHEET

FLASH TAPE 1

FLASH TAPE 1 is a general-purpose high temperature, fully cured silicone adhesive tape. Designed for use primarily in plastic and bonding shops for “flash” control, masking, holding, or positioning. It is equally useful for chemical milling operations, riveting and in paint departments. Flash Tape 1 is excellent on panels or parts being subjected to etching by either acid or other caustic solution.

SPECIFICATIONS

Thickness:	.002" Total Tape Thickness
Width:	1" and 2" Standard
Length:	72 yards per roll - Standard
Adhesion:	20 oz. per inch width
Elongation:	100 %
Temperature Range:	-60 - 400 degrees F (-51 - 204 degrees C)
Color:	Blue

NOTE: Technical information furnished by HAWKEYE is based on laboratory findings and is believed to be correct. No warranties of any kind are made except that materials supplied are HAWKEYE standard quality. All risk and liability arising from handling, storage and use of HAWKEYE products, as well as compliance with applicable legal restrictions rests with the buyer.

DATA SHEET

FLASH TAPE 2

FLASH TAPE 2 is an all-purpose, high temperature, fully cured silicone adhesive tape. It is designed for use when Flash Tape 1 does not provide enough flash resistance for an individual application.

FLASH TAPE 2 is intended for use primarily in plastic and bonding shops for "flash" control, masking, or position. It is equally useful elsewhere, for chemical milling operations, riveting and in paint departments. This tape is excellent on panels or parts being subjected too etching by either acid or other caustic solutions.

SPECIFICATIONS

Thickness:	.003" Total Tape Thickness
Width:	1" and 2" widths - Standard
Length:	72 yards per roll - Standard
Adhesion:	20 oz. per inch width
Elongation:	100 %
Temperature Range:	-60 - 400 degrees F (-51 - 204 degrees C)
Color:	Blue

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FLASH TAPE 1R

FLASH TAPE 1R is a general purpose, high tensile polyester film with a rubber adhesive. It is designed for use primarily in plastic and metal bonding shops, where silicone adhesive has been deemed inadvisable. Recommended uses include "flash" control, masking, holding and positioning.

SPECIFICATIONS

Thickness:	002" Total Tape Thickness
Width:	1" and 2" - Standard
Length:	72 yards per roll - Standard
Adhesion:	40 oz. per inch width
Elongation:	60%
Temperature Range:	-60 - 350 degrees F (-51 - 176 degrees C)

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FLASH TAPE 2R

FLASH TAPE 2R is a general-purpose polyester tape, with high-tensile strength. It is intended for use when a rubber adhesive is required and Flash Tape 1R does not provide adequate strength for a particular application.

FLASH TAPE 2R has been designed for use in plastic and metal bonding shops for “flash” control, positioning, masking, riveting and paint departments.

SPECIFICATIONS

Thickness:	.003” Total Tape Thickness
Width:	1” and 2” - Standard
Length:	72 yards per roll - Standard
Adhesion:	40 oz per inch width
Elongation:	80%
Temperature:	-60 - 350 degrees F (-51 - 176 degrees C)

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DATA SHEET

FLASH TAPE 1A

FLASH TAPE 1A is a general purpose, high tensile polyester film with an acrylic adhesive. It is designed for use primarily in plastic and metal bonding shops, where silicone adhesive has been deemed inadvisable. Recommended uses include "flash" control, masking, holding and positioning.

SPECIFICATIONS

Thickness:	.002" Total Tape Thickness
Width:	1" and 2" - Standard
Length:	72 yards per roll - Standard
Adhesion:	40 oz. per inch width
Elongation:	60%
Temperature Range:	-60 - 350 degrees F (-51 - 176 degrees C)

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DATA SHEET

FLASH TAPE 5

Flash Tape 5 is an all-purpose, high temperature, fully cured silicone adhesive tape. It is designed for use when Flash Tape 1 and 2 does not provide enough flash resistance for an individual application. Flash Tape 5 is a 5 mil high tensile polyester film coated with 1 1/2 mils of fully cured silicone adhesive.

Flash Tape 5 is applied to the tool or part so the excess adhesive will flow over it. At the completion of the cure cycle, the tape is pulled away which breaks the cured adhesive. This process leaves a clean bondline.

Flash Tape 5 can also be used for potting inserts. After the Flash Tape 5 has been placed on the part, drill through the tape and fill with insert and potting compound. After the cure, the Flash Tape 5 will pull away clean.

SPECIFICATIONS

Film Thickness (inches):	.005"
Adhesive Thickness (inches):	.0015"
Width:	1" and 2"
Roll Size:	36 yds per roll
Adhesion oz/inch/width:	20 to 25
Temperature Range	-40°F to 400°F (-51°C - 204°C)
Color:	Red or Blue
Shelf Life:	1 year when stored at 72°F (22°C)

* Other widths and lengths available

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DATA SHEET

FLASH TAPE 1RD

FLASH TAPE 1RD is an all-purpose double-backed tape, designed too hold items in place in vacuum bag layups. It adheres well to our various release products, and is ideal for holding honeycomb in place while machining. The tape is relatively inexpensive, and is economical when used in low temperature applications, although it will withstand temperatures of 350 degrees F (176 degrees C) for normal usage.

Flash Tape 1RD is a 1 mil polyester film coated on both sides with a non-silicone adhesive and is offered in both 1 and 2 inch widths as standard size.

SPECIFICATIONS

Thickness:	.0035" Total Thickness
Width:	1" and 2" - Standard
Length:	72 yards per roll - Standard
Color:	Yellow
Elongation:	60%
Temperature:	-40 - 350 degrees F (-40 - 176 degrees C)

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DATA SHEET

HK 1CBS PRESSURE SENSITIVE TAPE

HK 1CBS PRESSURE SENSITIVE TAPE is an all-purpose double-backed tape, designed too hold items in place in vacuum bag layups. It adheres well to our various release products, and is ideal for holding honeycomb in place while machining. The tape is relatively inexpensive, and is economical when used in low temperature applications, although it will withstand temperatures of 350 degrees F (176 degrees C) for normal usage.

HK 1 CBS PRESSURE SENSITIVE TAPE is a 1 mil polyester film coated on both sides with a non-silicone adhesive and is offered in both 1 and 2 inch widths as standard size.

SPECIFICATIONS

Thickness:	.0025" Total Thickness
Width:	1" and 2" - Standard
Length:	72 yards per roll - Standard
Color:	Clear
Elongation:	100%
Temperature:	-40 - 350 degrees F (-40 - 176 degrees C)

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DATA SHEET

HK1150 HONEYCOMB HOLD DOWN TAPE

HK1150 HONEYCOMB HOLD DOWN TAPE is a ten mil double-backed tape used primarily in honeycomb laydown. The thick adhesive is designed for core impediment. The adhesive is a non-silicone to prevent core contamination. For complete release of honeycomb from the HK1150, the cells should be sprayed with MEK or acetone.

SPECIFICATIONS

Thickness:	.010" Total Tape Thickness
Width:	1" and 2" - Standard
Length:	25 and 36 yards per roll - Standard
Adhesive Base:	Non-Silicone
Elongation:	15%
Adhesive:	90 oz./inch width
Temperature:	200 degrees F (93 degrees C) Maximum Recommended

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HK10CBS TAPE HONEYCOMB HOLD DOWN TAPE

HK10CBS HONEYCOMB HOLD DOWN TAPE is a ten mil double-backed tape used primarily in honeycomb laydown. The thick adhesive is designed for core impediment. The adhesive is a non-silicone too prevent core contamination. For complete release of honeycomb from the HK10CBS, the cells should be sprayed with MEK or acetone.

SPECIFICATIONS

Thickness:	.010" Total Tape Thickness
Width:	1" and 2" - Standard
Length:	25 and 36 yards per roll - Standard
Adhesive Base:	Non-Silicone
Elongation:	15%
Adhesive:	90 oz./inch width
Temperature:	200 degrees F (93 degrees C) Maximum Recommended

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HK1151 PRESSURE SENSITIVE TAPE

HK1151 PRESSURE SENSITIVE TAPE is a 2 mil., high temperature nylon tape, coated with a pressure sensitive rubber-base adhesive. Contamination problems common with silicone adhesive are eliminated with HK1151.

This tape is designed to provide clean removal during masking operation in applications involving high temperature and pressure. The tape is thin, but exceptionally tough. Elongation properties provide a high degree of conformability. The tape has very low shrinkage in high temperature applications is essentially pin-hole free.

- METAL BOND MASKING - Non-silicone adhesive allows use on parts where subsequent painting or bonding is necessary. Removes clean after 350 degrees F (176 degrees C) autoclave exposure.
- HIGH TEMPERATURE BAKE CYCLES - Clean removal from metal has been experienced after 24 hours at 350 degrees F (176 degrees C). In shorter cycles, the tape can be expected to provide satisfactory performance in 400 degree F (204 degree C) bake cycles. The high stretch and thinness offer excellent conformability and clean sharp edges.

SPECIFICATIONS

Thickness:	.0035" total tape thickness
Width:	1" and 2" - Standard
Length:	72 Yards - Standard
Color:	White
Elongation:	500%
Adhesion to Steel:	32 oz/inch width
Temperature:	100 - 400 degrees F (37 - 204 degrees C)

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DATA SHEET

FLASH RELEASE 2

FLASH RELEASE 2 is a high temperature fluorocarbon 2 mil pressure sensitive tape with a fully cured silicone adhesive. Fully cured silicone adhesives do not transfer to parts. This tape is transparent and is therefore useful for “see-through” applications. Flash release 2 is offered in standard roll widths of 1 and 2 inches.

FLASH RELEASE 2 is designed for high temperature work where tough release problems exist, or in oven and autoclave operations. It will release from all resin systems without leaving a residue, and is ideal for masking in chemical milling and chemical processing.

SPECIFICATIONS

Backing Material	.002” FEP Film
Adhesive	fully cured silicone
Adhesive Thickness:	.0015”
Thickness:	.0035” Total Thickness
Width:	1” and 2” - Standard
Length:	36 Yards - Standard
Color:	Transparent
Elongation:	275%
Adhesion to Steel	20 oz./inch width
Tensil Strength	8 lbs/in
Dielectric Strength	9000 volts
Temperature:	-100 - 500 degrees F (-73 - 260 degrees C)

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